

Amendment and Request for Reconsideration
December 13, 2005

Appl. No. 09/747,594

In the Claims:

1. (Previously presented) A continuous method of cutting a plurality of moist substrates comprising:
 - a) placing a wound log of moist substrate on a conveyor, the log having a length, a width and a moisture content of at least about 50%;
 - b) advancing the conveyor;
 - c) discharging the log from the conveyor onto a transfer plate;
 - d) placing the log into a pocket on a cutting support;
 - e) advancing the pocket containing the log toward a plurality of cutting blades;
 - f) advancing the pocket containing the log through the cutting blades, whereby the log is cut into a number of shorter rolls;
 - g) advancing the pocket containing the rolls away from the cutting blades;
 - h) discharging the rolls from the pocket; and,

repeating steps a) through h) in a continuous manner.
2. (Original) The method of claim 1, wherein the log is at least 2540 mm long.
3. (Original) The method of claim 1, wherein the log has a diameter of from about 50 mm to about 140 mm.
4. (Original) The method of claim 1, wherein at least 95% of the log is cut into useable rolls.
5. (Original) A method of cutting a coreless wet wipes log comprising:
 - a) placing a coreless wet wipes log in a pocket, the log having a length of at least 2540 mm, a diameter of from about 50 mm to about 140 mm and a moisture content of at least 50%;
 - b) advancing the pocket containing the log toward a cutting position;
 - c) cutting the log into a plurality of rolls in the cutting position;

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d) the pocket maintaining the shape, integrity and position of the log as it is cut into rolls without the need for clamps and with out the need for a mandrel; and,

e) discharging the rolls from the pocket.

6. (Original) The method of claim 5, wherein steps a) through e) are repeated in a continuous process resulting in the production of at least 300 rolls per minute.

7. (Original) The method of claim 5, wherein a conveyor is used to place the logs in the pockets.

8. (Original) The method of claim 5, wherein the rolls are discharged into a diverter.

9. (Original) The method of claim 5, wherein at least 95% of the log is cut into useable rolls.

10. (Original) A method of making a plurality of wet wipes rolls comprising:

- a) placing a wet wipes log on a conveyor, the log having a length, a width and a moisture content of at least about 65%;
- b) advancing the conveyor;
- c) discharging the log from the conveyor into a holding support;
- d) advancing the support containing the log toward a plurality of cutting blades;
- e) engaging the log and the cutting blades, whereby the log is sectioned into a plurality of rolls; and,

repeating steps a) through e) so that at least 300 rolls are produced per minute.

11. (Original) The method of claim 10, wherein the log is at least 2540 mm long.

12. (Original) The method of claim 10, wherein the log has a diameter of from about 50 mm to about 250 mm.

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13. (Original) The method of claim 10, wherein at least 95% of the log is cut into useable rolls.

14. (Original) A continuous method of cutting a plurality of wet wipes logs comprising:

- a) placing a coreless wet wipes log on a conveyor, the log having a length, a width and a moisture content of at least about 50%;
- b) advancing the conveyor;
- c) discharging the log from the conveyor onto a transfer plate;
- d) metering the rate at which the log is discharged from the transfer plate to a pocket;
- e) advancing the pocket containing the log toward a plurality of cutting blades;
- f) engaging the log in the pocket with the cutting blades, whereby the log is cut into a number of shorter rolls;

- g) discharging the rolls from the pocket;
- h) repeating steps a) through g) in a continuous manner; and,

periodically interrupting the repetition of steps a) through g) to move the cutting blades to a position away from pocket; and,

honing the cutting blades while in the away position, whereby material from the honing does not contaminate the pocket, the log, or the rolls.

15. (Original) The method of claim 14, wherein the log is at least 2540 mm long.

16. (Original) The method of claim 14, wherein the log has a diameter of from about 50 mm to about 140 mm.

17. (Original) The method of claim 14, wherein at least 95% of the log is cut into useable rolls.

Claims 18-30 (Cancelled)

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31. (Currently Amended) A method of cutting a plurality of flexible and moist substrates comprising:

- a) placing a flexible and moist log on a conveyor, the flexible and moist log having a length and a width;
- b) advancing the conveyor;
- c) discharging the flexible and moist log from the conveyor into a pocket; the pocket containing channels therein;
- d) advancing the pocket containing the flexible and moist log toward a plurality of cutting blades;
- e) engaging the flexible and moist log and the cutting blades, whereby the flexible and moist log is sectioned into a plurality of moist rolls; and,
repeating steps a) through e) so that at least 300 moist rolls are produced per minute.

32. (Currently Amended) The method of claim 31, wherein the flexible and moist log is at least 2540 mm long.

33. (Currently Amended) The method of claim 31, wherein the flexible and moist log has a diameter of from about 50 mm to about 250 mm.

34. (Currently Amended) The method of claim 31, wherein at least 95% of the flexible and moist log is cut into useable moist rolls.

35. (Currently Amended) A continuous method of cutting a plurality of flexible and moist logs comprising:

- a) placing a flexible and moist log on a conveyor, the flexible and moist log having a length and a width;
- b) advancing the conveyor;
- c) discharging the flexible and moist log from the conveyor onto a transfer plate;

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d) metering the rate at which the flexible and moist log is discharged from the transfer plate to a pocket, the pocket having channels therein;

e) advancing the pocket containing the flexible and moist log toward a plurality of cutting blades;

f) engaging the flexible and moist log in the pocket with the cutting blades, whereby the flexible and moist log is cut into a number of shorter moist rolls;

g) discharging the moist rolls from the pocket;

h) repeating steps a) through g) in a continuous manner; and,
periodically interrupting the repetition of steps a) through g) to move the cutting blades to a position away from pocket; and,
honing the cutting blades while in the away position, whereby material from the honing does not contaminate the pocket, the flexible and moist log, or the moist rolls.

36. (Currently Amended) The method of claim 35, wherein the flexible and moist log is at least 2540 mm long.

37. (Currently Amended) The method of claim 35, wherein the flexible and moist log has a diameter of from about 50 mm to about 140 mm.

38. (Currently Amended) The method of claim 35, wherein at least 95% of the flexible and moist log is cut into useable moist rolls.

39. (Currently Amended) A continuous method of cutting a plurality of moist substrates comprising:

- a) placing a moist log of substrate on a conveyor, the moist log having a length and a width;
- b) advancing the conveyor;
- c) discharging the moist log from the conveyor onto a transfer plate;
- d) placing the moist log into a pocket on a cutting support, the pocket having channels therein; wherein the pocket supports the moist log along the entire length;

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- e) rotating the pocket containing the moist log toward a plurality of circular cutting blades;
- f) rotating the pocket containing the moist log through the circular cutting blades, whereby the moist log is cut into a number of shorter moist rolls;
- g) rotating the pocket containing the moist rolls away from the cutting blades;
- h) discharging the moist rolls from the pocket; and,
repeating steps a) through h) in a continuous manner.

40. (New) The method of claim 1, further comprising transporting the wound log of moist substrate in a direction perpendicular to the length of the moist log.

41. (New) The method of claim 1, further comprising rotating the cutting blades in a direction counter to advancing the pocket.

42. (New) The method of claim 5, further comprising transporting the coreless wet wipes log in a direction perpendicular to the length of the log.

43. (New) The method of claim 10, further comprising transporting the wet wipes log in a direction perpendicular to the length of the wet wipes log.

44. (New) The method of claim 10, further comprising rotating the cutting blades in a direction counter to advancing the support.

45. (New) The method of claim 14, further comprising transporting the coreless wet wipes log in a direction perpendicular to the length of the coreless wet wipes log.

46. (New) The method of claim 14, further comprising rotating the cutting blades in a direction counter to advancing the pocket.

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47. (New) The method of claim 31, further comprising transporting the flexible and moist log in a direction perpendicular to the length of the flexible and moist log.

48. (New) The method of claim 31, further comprising rotating the cutting blades in a direction counter to advancing the pocket.

49. (New) The method of claim 35, further comprising transporting the flexible and moist log in a direction perpendicular to the length of the log.

50. (New) The method of claim 35, further comprising rotating the cutting blades in a direction counter to advancing the pocket.

51. (New) The method of claim 39, further comprising transporting the moist log in a direction perpendicular to the length of the moist log.

52. (New) The method of claim 39, further comprising rotating the circular cutting blades in a direction counter to rotating the pocket.